

# Work Order ID 91988

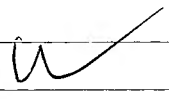
**\*91988\***

Page 1

October-19-12 7:43:49 AM

Item ID: D3282-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Float Web (206L/407)  
 Start Date: 10/19/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 11/02/12 Req'd Qty: 10.00 **\*10\*** Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	D

100	Skidtubes	0.00							
<b>*100*</b>	Memo	0.00							
Skidtubes	1-Cut to length as per Dwg D3282.								
Skidtubes	2- inspect for surface damage as per QSI0018								
	3- Deburr								

*DL 12/10/19*

110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>	Memo	0.00							
HAAS 1	1-Machine as per Folio FA579 & Dwg D3282								
HAAS CNC vertical machine #1	2-Deburr								

*FK 12/10/23*  
*2P 12-10-24*

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>	Memo	0.00							
QC									
Quality Control									

*FK 12/10/23*  
*1P 12-10-24*

# Work Order ID 91988

**\*91988\***

Page 2

October-19-12 7:43:49 AM

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

BA

12/10/26

10

0

DAS  
08  
2-83

10

NA

12-10-30

10

SMD

12-10-30



**\*91988\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/19/12      **Start Qty:** 10.00

**\*10\***

**Cust Item ID:**

**Required Date:** 11/02/12      **Req'd Qty:** 10.00

\*10\*

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date:

**Tooling:**

Date:

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

**Insp.  
Stamp**

0.00

**\*160\***

## Skidtubes

0.00

## Skidtubes

## Memo

## Skidtubes

1-Install doublers as per Dwg D3282.

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

0.00

QC

## Memo

## Quality Control

180

Identify as per dwg & Stock Location: 16

0.00

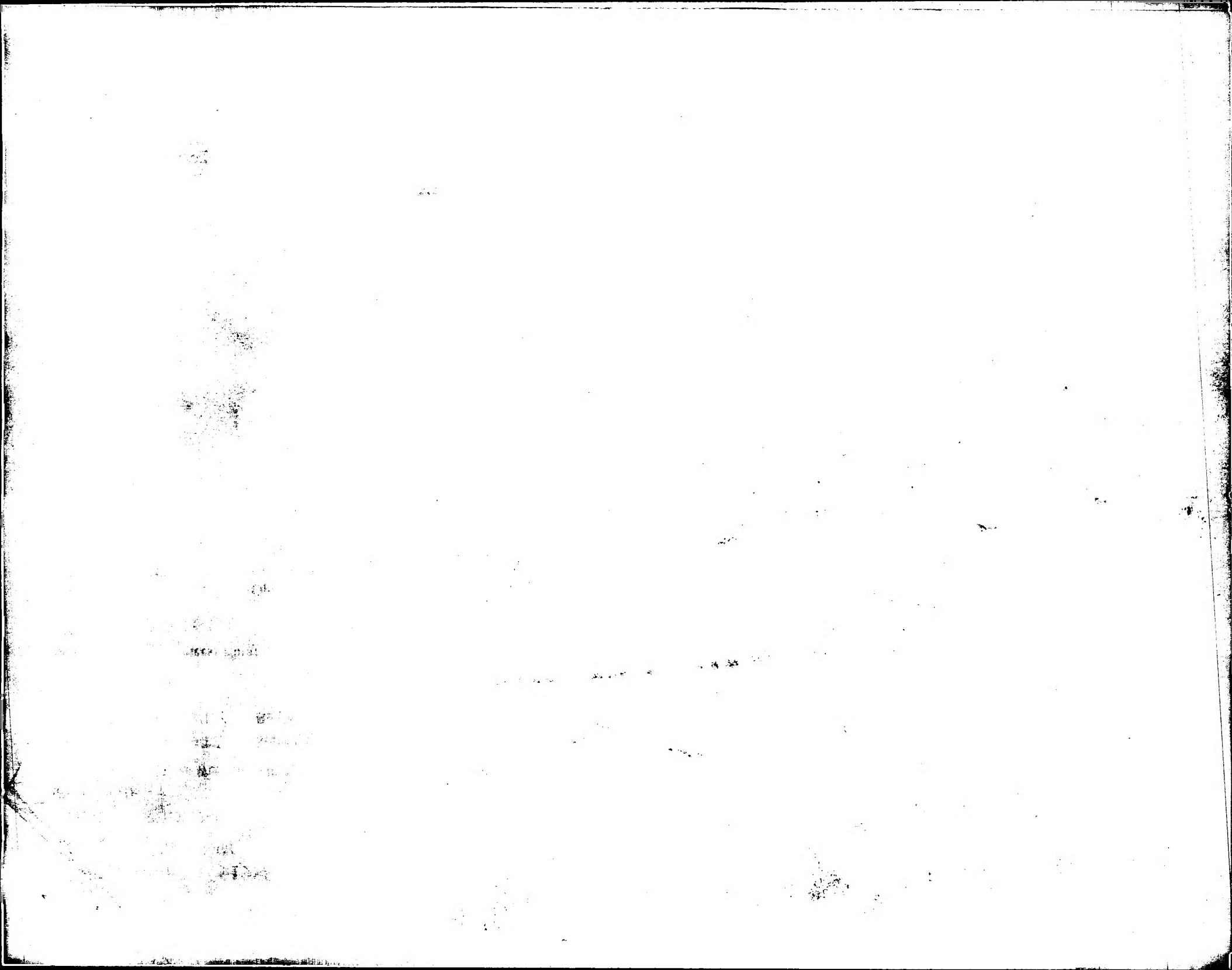
**\*180\***

0.00

### Packaging

## Memo

## Packaging



# Picklist Print

October-19-12 7:43:48 AM

Page 1

Work Order ID: 91988

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/19/12

Required Date: 11/02/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM IPP REV:C 11.09.20 remove LPS as per dwg  
revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130 EXTRUSION		Manufactured	No			100	Each	10.0000	1	10		DC 12/10/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		10							
				72839		10							
D3283-1 Doubler		Manufactured	No			160	Each	28.0000	2	20		SAD 12-10-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST176		28							
				82125		4							
				85511		24							
MS20470AD4-7 Rivet, Universal Head		Purchased	No			160	Each	1,741.0000	57	570		SAD 12-10-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				336		1300							
				122452		1300						570	
				ST139		124							
				121415		124							
				ST319		52							
				120769		52							
				ST320		265							
				116081		117							
				118614		148							

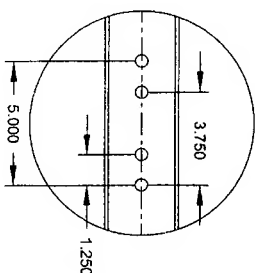
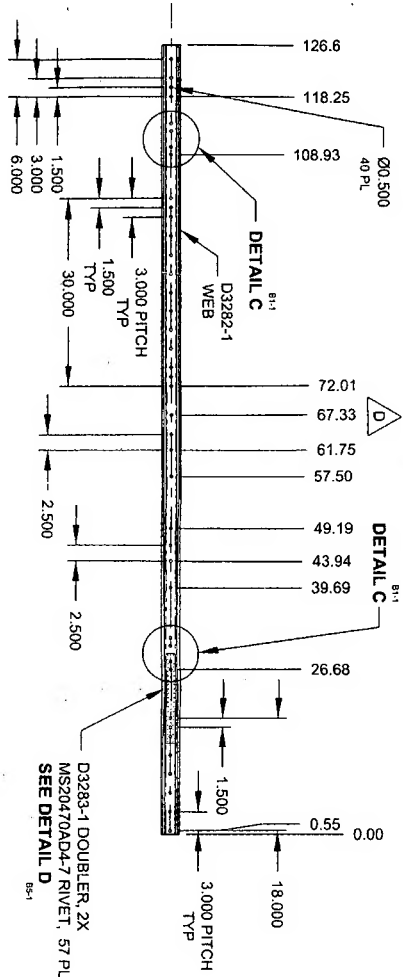
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 91958
<b>Description:</b> Float Web		<b>Part Number:</b> D3282-041
<b>Inspection Dwg:</b> D3282	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

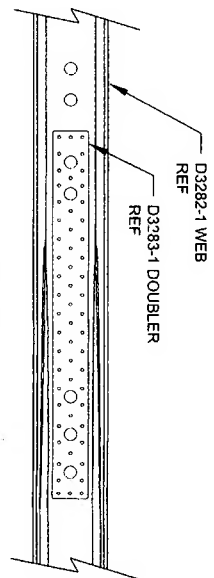
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.625	✓		FK-05	Tape
1.500	+/-0.010	1.500	✓		FK-04	Vern.
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		Tape	FK-05
1.500	+/-0.010	1.500	✓		FK-04	Vern.
72.01	+/-0.030	72.01	✓		FK-05	Tape
61.75	+/-0.030	61.75	✓		"	"
57.50	+/-0.030	57.50	✓		"	"
49.19	+/-0.030	49.19	✓		"	"
43.94	+/-0.030	43.94	✓		"	"
39.69	+/-0.030	39.69	✓		"	"
26.68	+/-0.030	26.68	✓		"	"
0.55	+/-0.030	.55	✓		FK-04	Vern.
1.970	+/-0.010	1.970	✓		"	"
2.38	+/-0.030	2.375	✓		"	"
0.05	+/-0.030	.50	✓		"	"

<b>Measured by:</b> FK.	<b>Audited by:</b> D.A. (DAS 08 28)	<b>Preliminary Approval:</b>
<b>Date:</b> 12/10/23	<b>Date:</b> 12/10/26	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	



DETAIL D



DETAIL C

NOTE: RIVET HOLES/DOUBLER NOT SHOWN FOR CLARITY

RELEASED  
R 2011-09-21

- NOTES:
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005.4.1
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK: ALL SHARP EDGES 0.010 TO 0.020
  - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER OSI 044.6.1 (FINE POINT PERMANENT INK MARKER)
  - 7) WEIGHT: 20.0 lbs
  - 8) SEE PAGE 2 FOR MACHINING DETAILS

REV.	DESCRIPTION	BY	DATE
D	ADD ADDITIONAL HOLE (2N D6-1); REMOVE LPS-3	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
DESIGN	CP		
DRAWN	SC		
CHECKED	CP		
WFG. APPR.	D3282		
APPROVED			
DE APPR.	WEB		
DATE	11.05.05		

DART AEROSPACE USA, INC  
PORT HADLOCK, WA  
SHEET 1 OF 2  
SCALE  
N/S

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RELEASED  
2011-09-12

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	<b>PORT HADLOCK, WA</b>	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG APPR.	<i>[Signature]</i>	D3282	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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